

Date: Thursday, 4/12/2007 8:45:13 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	31722		Part Number	D2574		
Estimate Number	10534		Drawing Number	D2574 REV E		
P.O. Number	N/A		Project Number	N/A		
This Issue	4/12/2007	S.O. No.	Type	MACHINED PARTS	Drawing Revision	E
Prsht Rev.	NC		Material	N/A		
First Issue	N/A		Due Date	4/30/2007		
Previous Run	31718		Qty:	16	Um: Each	
Written By			Comment	Est Rev: 1 As Per RevE 06-01-27 JLM		
Checked & Approved By	<u>John 04.12</u>					
Comment						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D6101005	7075-T7351 8.25X5.0X2.5		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: _____		B85352 16 En 07/05/06
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. 331722 Double check by: SD		
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.		MS / En 07/05/16 (x16)
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE		
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574		MS / En 07/05/16 (x16)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		MS / En 07/05/16 (x16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:45:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 31722

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 07-05-15

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

el

07-05-16 16

7.0 POWDER COATING POWDER COATING



M103706

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

el

07-05-17 16

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M.J.

07/05/17

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

STY33

PC 7/05/17 (16)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/18

Job Completion



U 07-05-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31722
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	-DT8682-	.440	.440	.440	.440		
B	1.745	1.755		1.748	1.748	1.750	1.750		
C	3.495	3.505		3.500	3.501	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.000	8.001		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.378	.378	.378	.378		
I	0.490	0.510		.500	.501	.501	.501		
J	1.174	1.184		1.174	1.179	1.174	1.179		
K	0.558	0.578		.560	.561	.561	.561		
L	1.174	1.184		1.174	1.179	1.179	1.179		
M	1.365	1.375		1.368	1.368	1.368	1.368		
N	2.495	2.505		2.500	2.501	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.125	.128	.128	.128		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.125	.125	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		.240	.242	.240	.240		
W	0.115	0.135		.125	.125	.125	.125		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.501	.502	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.512	1.512	1.512		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.000	2.001	2.001	2.001		
AJ	0.023	0.043		.032	.032	.032	.032		

Accept/Reject

Measured by:	MS /	Audited by:	SK
Date:	07/05/09	Date:	07.05.15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK JLM

DART AEROSPACE LTD	Work Order:	31722
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.747	1.749	1.748	1.748		
C	3.495	3.505		3.500	3.499	3.501	3.500		
D	1.745	1.755		1.747	1.749	1.748	1.748		
E	7.990	8.010		8.003	8.004	8.004	8.002		
F	0.490	0.510		0.496	0.494	0.500	0.495		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.500	0.497	0.500		
J	1.174	1.184		1.176	1.175	1.178	1.175		
K	0.558	0.578		0.566	0.565	0.566	0.566		
L	1.174	1.184		1.176	1.175	1.178	1.175		
M	1.365	1.375		1.367	1.367	1.368	1.366		
N	2.495	2.505		2.497	2.497	2.498	2.498		
O	4.119	4.129		4.122	4.122	4.122	4.121		
P	0.115	0.135		0.128	0.128	0.128	0.128		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.253	0.254	0.253		
S	0.115	0.135		0.125	0.124	0.124	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.239	0.238	0.241	0.238		
W	0.115	0.135		0.129	0.131	0.129	0.131		
X	0.307	0.312		0.310	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.369	0.369	0.369		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.628	0.624	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.248	0.246	0.249		
AE	1.500	1.520		1.510	1.510	1.509	1.509		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.247	0.252	0.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EP / MS
Date:	07.05.11

Audited by:	SD
Date:	07.05.11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK

DART AEROSPACE LTD	Work Order:	31722
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.748	1.749	1.750		
C	3.495	3.505		3.506	3.498	3.501	3.500		
D	1.745	1.755		1.749	1.748	1.749	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		0.499	0.496	0.499	0.500		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.379	0.379		
I	0.490	0.510		0.497	0.496	0.496	0.499		
J	1.174	1.184		1.178	1.176	1.175	1.175		
K	0.558	0.578		0.565	0.565	0.564	0.565		
L	1.174	1.184		1.178	1.176	1.175	1.179		
M	1.365	1.375		1.368	1.365	1.365	1.367		
N	2.495	2.505		2.499	2.497	2.499	2.500		
O	4.119	4.129		4.123	4.123	4.123	4.123		
P	0.115	0.135		0.128	0.127	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.252	0.252	0.252		
S	0.115	0.135		0.126	0.126	0.126	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.240	0.239	0.240		
W	0.115	0.135		0.134	0.135	0.134	0.132		
X	0.307	0.312		0.310	0.311	0.310	0.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.362	0.363	0.365		
AA	0.470	0.530		0.500	0.500	0.506	0.500		
AB	0.615	0.635		0.628	0.628	0.629	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.249	0.249	0.250		
AE	1.500	1.520		1.510	1.508	1.508	1.509		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.247	0.249	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EP/MB
Date:	01/05/14

Audited by:	SD
Date:	07.05.15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31722
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.499	3.500		
D	1.745	1.755		1.750	1.751	1.749	1.749		
E	7.990	8.010		8.000	8.002	8.004	8.004		
F	0.490	0.510		.500	.499	0.499	0.498		
G	0.257	0.262	DT8683	.258	.258	0.260	0.265		
H	0.375	0.380	DT8684	.376	.376	0.377	0.377		
I	0.490	0.510		.501	.501	0.500	0.499		
J	1.174	1.184		1.179	1.179	1.176	1.178		
K	0.558	0.578		.568	.569	0.572	0.565		
L	1.174	1.184		1.179	1.179	1.176	1.178		
M	1.365	1.375		1.370	1.370	1.368	1.368		
N	2.495	2.505		2.500	2.499	2.498	2.497		
O	4.119	4.129		4.123	4.123	4.120	4.120		
P	0.115	0.135		.132	.132	0.126	0.126		
Q	0.115	0.135		.130	.130	0.135	0.135		
R	0.240	0.260		.250	.250	0.251	0.251		
S	0.115	0.135		.125	.125	0.122	0.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.231	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	0.241	0.239		
W	0.115	0.135		.125	.125	0.135	0.135		
X	0.307	0.312		.312	.312	0.311	0.311		
Y	0.760	0.765		.762	.762	0.765	0.765		
Z	0.352	0.372		.365	.365	0.362	0.362		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		.625	.625	0.625	0.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	0.250	0.251		
AE	1.500	1.520		1.509	1.510	1.510	1.509		
AF	0.115	0.135		.125	.125	0.135	0.135		
AG	0.240	0.280		.260	.260	0.260	0.260		
AH	0.240	0.260		.250	.250	0.248	0.248		
AI	2.000	2.020		2.007	2.005	2.000	2.000		
AJ	0.023	0.043		.032	.032	.032	.032		
Accept/Reject									

Measured by:	MS	/		Audited by:	JK	/	
Date:	07/05/14	/	07/05/15	Date:	07.05.15	/	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK



